

Work Order ID 147832

Thursday, June 16, 2016 9:18:15 AM

147832

Page 1

Item ID: D5155-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head (212)

Start Date: 6/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: **JUN 16 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5155	B

100	Cut blanks as per folio	0.00							DAS 08 9-89
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK AT 4.900"								

110		0.00							
110									
HAAS 5AXIS	Memo	0.00							DAS 08 9-89
HAAS CNC vertical machine #5	MACHINE AS PER DWG & FOLIO FB349/ D5155-11								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								

DO NOT BUFF OR POLISH PART

DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ ♦ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 147832

Thursday, June 16, 2016 9:18:15 AM

147832

Page 2

Item ID: D5155-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head (212)

Start Date: 6/10/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC1- Inspection performed by CMM QC2 Memo Inspect on CMM as per folio CMMA033. DWG REV: _____ CMM PROG. REV: _____	0.00 0.00		16/06/20		4	0		DAS 08 9-89
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		DAS 32 SL 9-89 16-6-21
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(4)			DAS 38 9-89 JUN 27 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ * Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 147832

Thursday, June 16, 2016 9:18:15 AM

147832

Page 3

Item ID: D5155-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head (212)

Start Date: 6/10/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Outsource process-Anodize per QSI017 4.1.10.1

0.00

150

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O TO ATG: 32971
ANODIZE BLACK AS PER MIL SPEC AND DWG

C OF CO IS REQUIRED

4
JUL 08 2016
DAS
13
9-89

155

Receive & Inspect for Damage & Mat'l Certs

0.00

155

Packaging

Memo

0.00

Packaging

4x 8/6-7-19

158

QC5- Inspect part completeness to step on W/O

0.00

158

QC

Memo

0.00

Quality Control

④

DAS
38
9-89
JUL 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147832

Thursday, June 16, 2016 9:18:15 AM

147832

Page 4

Item ID: D5155-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head (212)

Start Date: 6/10/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST375	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

4 DAS 8-89 11.1 1-9 2016

PS AA 16/6/22 MCS

DAS 21 8-89 JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, June 16, 2016 9:18:20 AM

Page 1

Work Order ID: 147832

147832

Parent Item: D5155-11

D5155-11

Parent Item Name: Co-Pilot Collective Head (212)

Start Date: 6/10/2016

Required Date: 6/23/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B
15.07.02 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	6.0200	0.409	1.722105			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

**

B.O 16/06/19

Location

Loc Qty

Loc Code

MAT004

6.02

→ m134776

6.02

1.650**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

DART AEROSPACE LTD	Work Order:	147832
Description: Co-Pilot Collective Head (212)	Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+0.010/-0.000	2.803	✓		H-6	31006
1.83	+/-0.030	1.830	✓		"	"
R0.19	+/-0.030	R0.188	✓		R-6	ref.
21°	+/-0.5°	21°	✓		Angle M.	CNC-17
0.227	+/-0.010	0.229	✓		H-6	31006
1.850	+/-0.010	1.846	✓		"	"
Ø0.125 x 0.350	+0.004/-0.001 x +/-0.010	Ø0.126 x .355	✓		Vern	GA-13
21°	+/-0.5°	21°	✓		Angle M.	CNC-17
2.547	+/-0.005	2.547	✓		Vern	GA-13
0.35	+/-0.030	0.356	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.35	+/-0.030	0.328	✓		Vern	GA-13
0.06	+/-0.030	0.062	✓		"	"
0.33	+/-0.030	0.346	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.500	+/-0.010	1.500	✓		H-6	31006
Ø0.150	+0.005/-0.001	Ø0.153	✓		Vern	GA-13
1.450	+/-0.010	1.452	✓		H-6	31006
R0.30	+/-0.030	R0.300	✓		R-6	ref.
R0.03	+/-0.030	R0.032	✓		"	"
0.100	+/-0.010	0.101	✓		Mic	118-120
3.000	+/-0.010	3.000	✓		Vern	GA-13
0.59	+/-0.030	0.588	✓		H-6	31006
1.82	+/-0.030	1.820	✓		Vern	GA-13
R0.30	+/-0.030	R0.300	✓		R-6	ref.
R0.25	+/-0.030	R0.250	✓		"	"
Ø0.150	+0.005/-0.001	Ø0.153	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.
2.400	+/-0.005	2.400	✓		Vern	GA-13
0.300	+/-0.010	0.300	✓		"	"
1.450	+/-0.010	1.451	✓		H-6	31006
1.750	+/-0.010	1.753	✓		"	"
Ø0.150	+0.005/-0.001	Ø0.153	✓		Vern	GA-13
2.70	+/-0.030	2.699	✓		H-6	31006
2.500	+/-0.010	2.499	✓		"	"
2.20	+/-0.030	2.202	✓		"	"
R0.30	+/-0.030	R0.300	✓		R-6	ref.

DART AEROSPACE LTD		Work Order:	147832
Description: Co-Pilot Collective Head (212)		Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 2 of 2	

INSPECTION SHEET

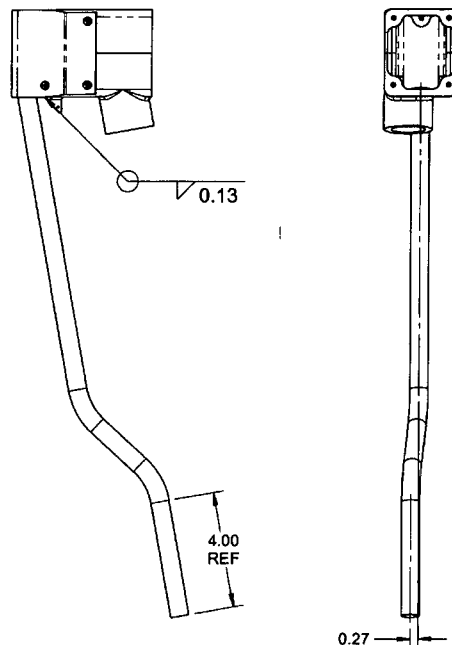
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.70	+/-0.030	0.699	✓		H-6	31006
0.20	+/-0.030	0.203	✓		Mic	118-120
4.700	+/-0.010	4.699	✓		Nern	6A-13
1.350	+/-0.010	1.351	✓		H-6	31006

Measured by: A.S. DAS 08	Checked by: 32 DAS 9-89	QC Inspector:
Date: 16/06/20	Date: 16-06-21	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.06.22	New Issue	KJ	
B	16.01.20	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5155-1	CO-PILOT COLLECTIVE HEAD (205)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100*

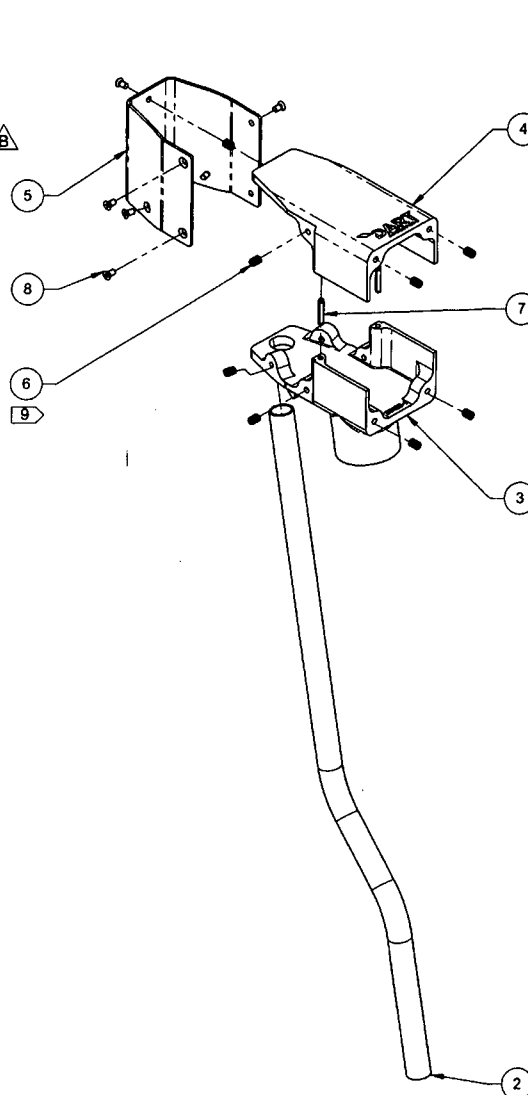


D5155-041 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.08 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 147832 MJS
1606-16

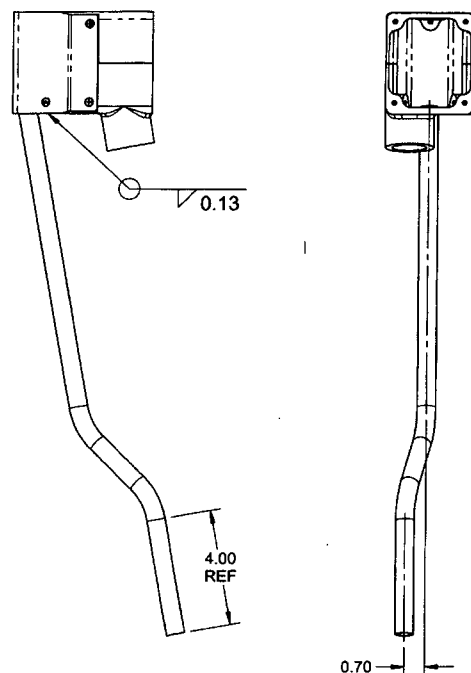
RELEASED

A.P. 2015 JUL 02 ECU 15-577

B	REVISE DIM: ZN D3-7, REVISE NOTE 2, ZN A8-13, A8-14, REVISE LENGTH OF PIN: ZN D6-1, D6-2, D5-3, D5-4, REVISE DEPTH: ZN C7-5, C7-7, C7-9, C7-11, C5-13, C4-14, REVISE DIM: ZN C7-5, C7-7, C7-9, C6-11, B7-13, B7-14, B2-5, B2-7, B2-9, B2-11, C5-13, C4-14, D8-6, D8-8, D8-10, D5-6, D5-8, D5-10, D5-12, B8-7, D7-12, C7-5, C7-7, C7-9, C6-11, D2-13, D2-14	VS	15.05.21
A	NEW ISSUE	VS	14.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	15.05.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 REV. B SHEET 1 OF 14 TITLE CO-PILOT COLLECTIVE HEAD SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5155-3	CO-PILOT COLLECTIVE HEAD (212)
4	1	D5155-11	CO-PILOT COLLECTIVE HEAD (212)
5	1	D5156-11	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100°

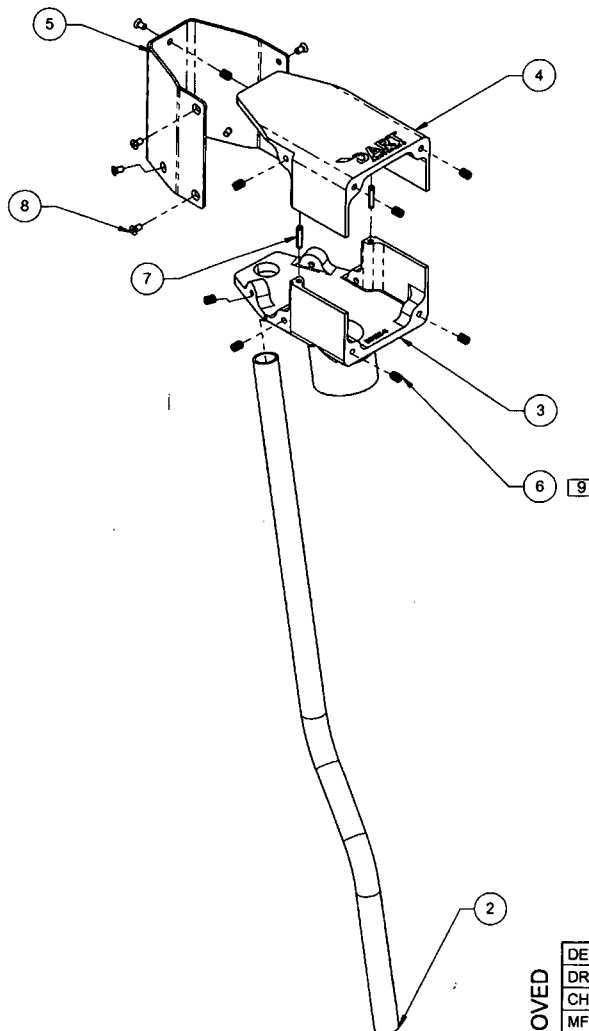


D5155-043 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-043 CO-PILOT COLLECTIVE HEAD ASSY (212)



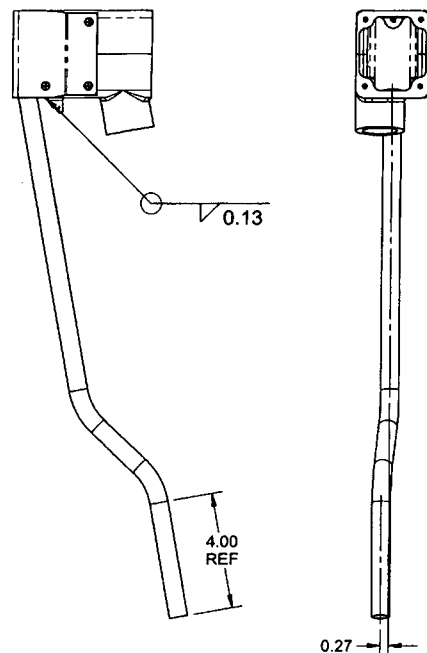
RELEASED

A-4. 2015 JUL 02

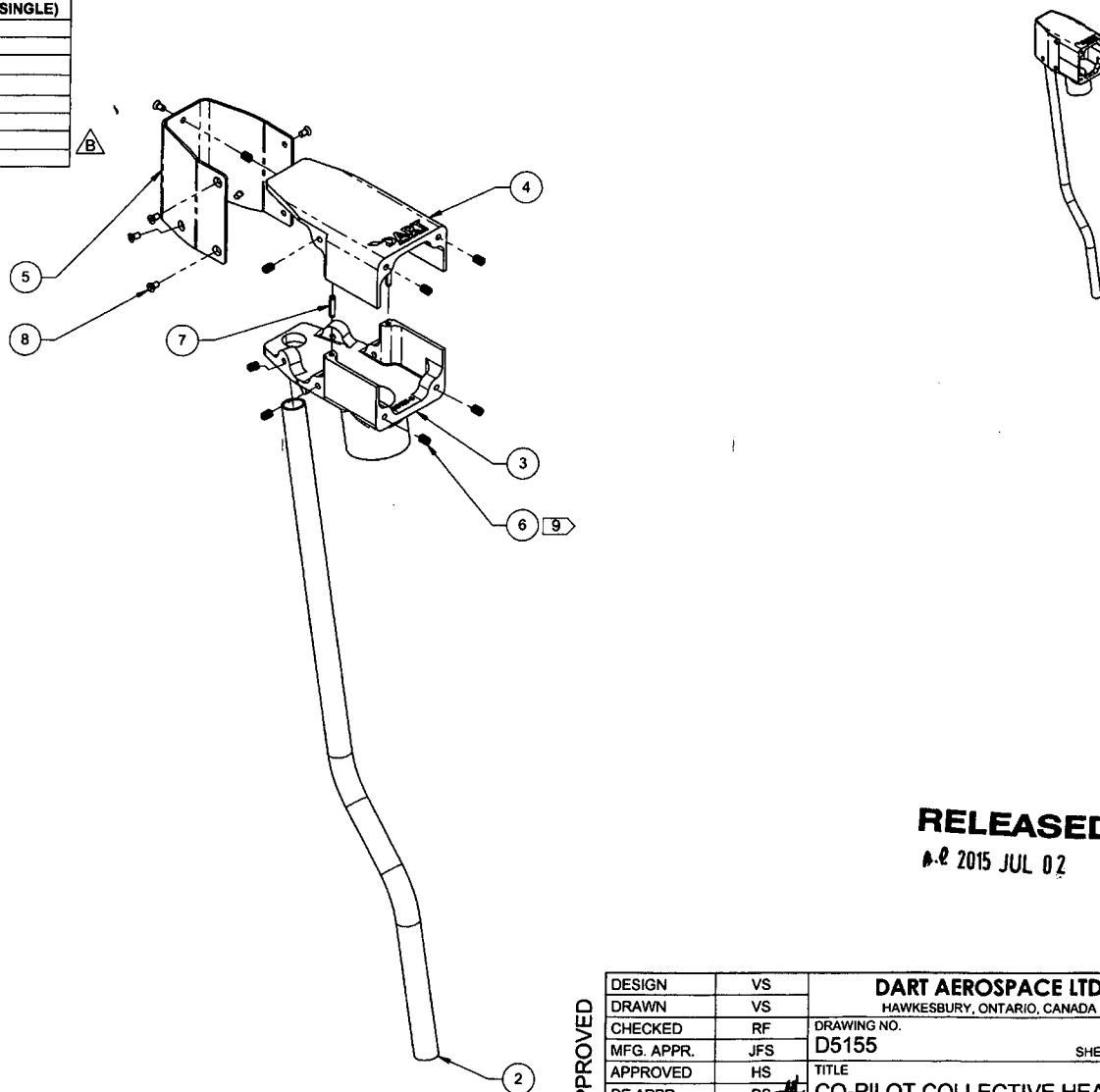
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 2 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5155-5	CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100*



D5155-045 WELDING DETAIL



D5155-045 CO-PILOT COLLECTIVE HEAD ASSY (EAGLE SINGLE)

NOTES:

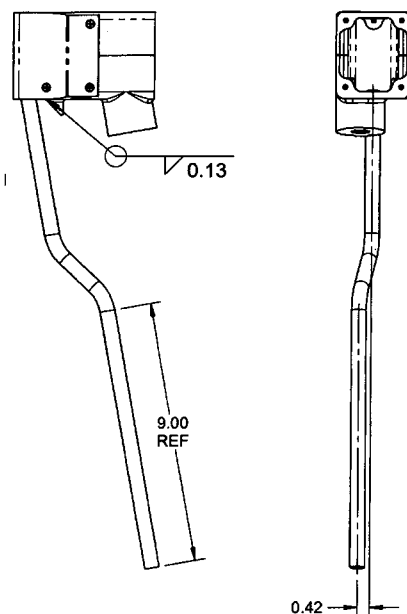
- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

RELEASED

1.2 2015 JUL 02

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 3 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24693-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING

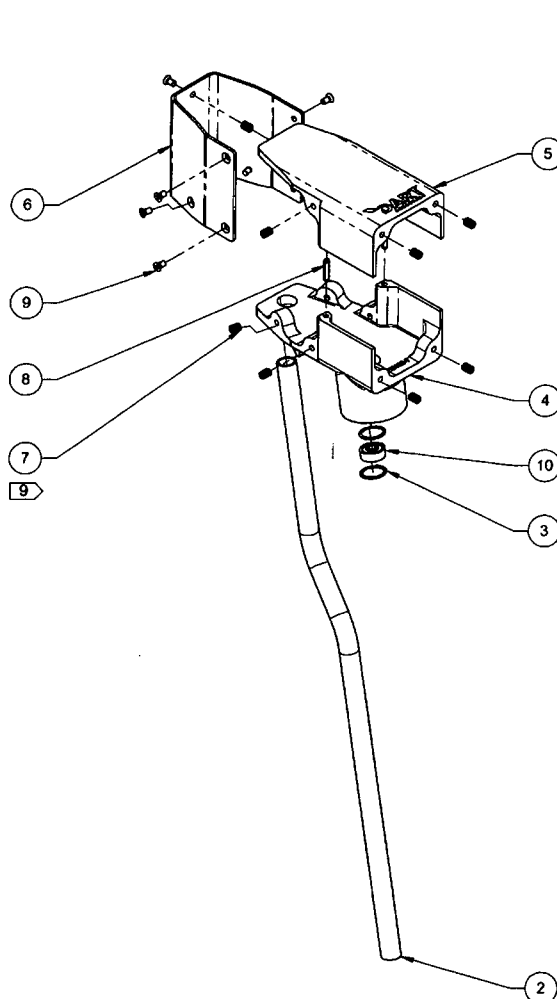


D5155-047 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.14 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

**D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED**

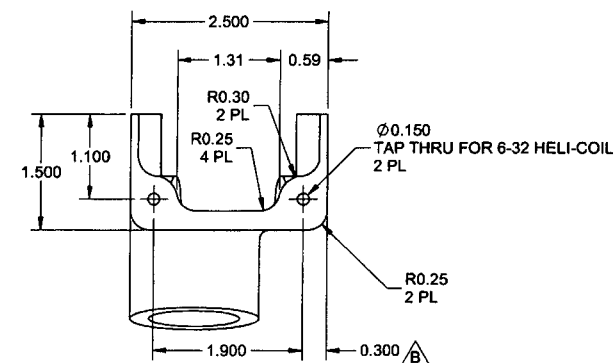
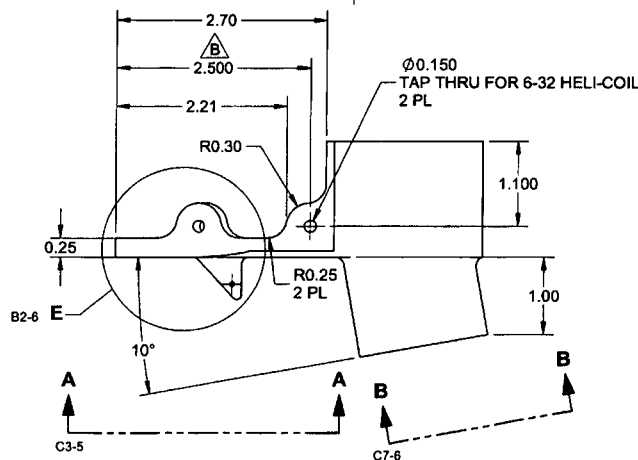
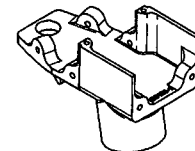
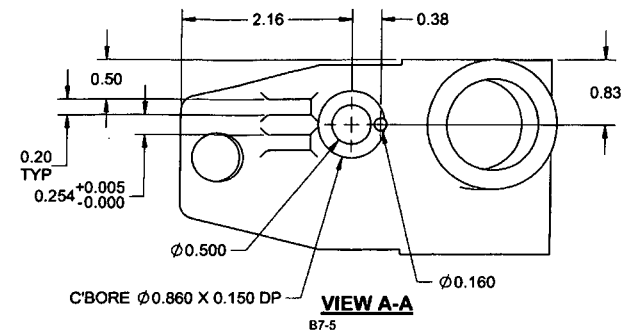


RELEASED

A-E 2015 JUL 02

APPROVED

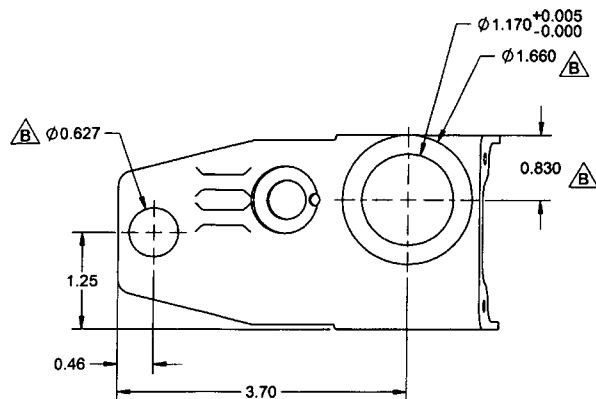
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



A.P. 2015 JUL 02

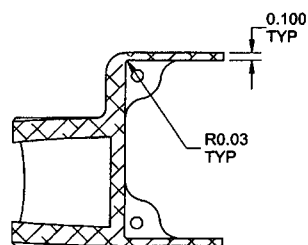
D5155-1 CO-PILOT COLLECTIVE HEAD (205)

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRINTED AND REPRODUCED BY THE COPYRIGHT OWNER. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM THE COPYRIGHT OWNER.	REV. B
	DRAWN	VS		SHEET 5 OF 14
	CHECKED	RF		SCALE
	MFG. APPR.	JFS		NTS
	APPROVED	HS		
	DE APPR.	DS		
DATE	15.05.21			



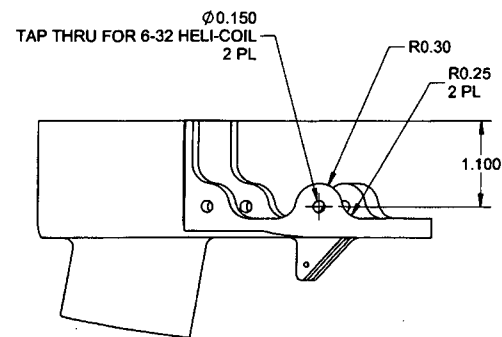
VIEW B-B

B5-5



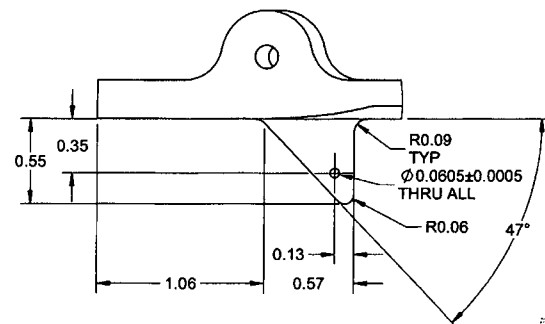
SECTION D-D

D6-5



VIEW C-C

D7-5



DETAIL

B7-5

RELEASED

A-2 2015 JUL 02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

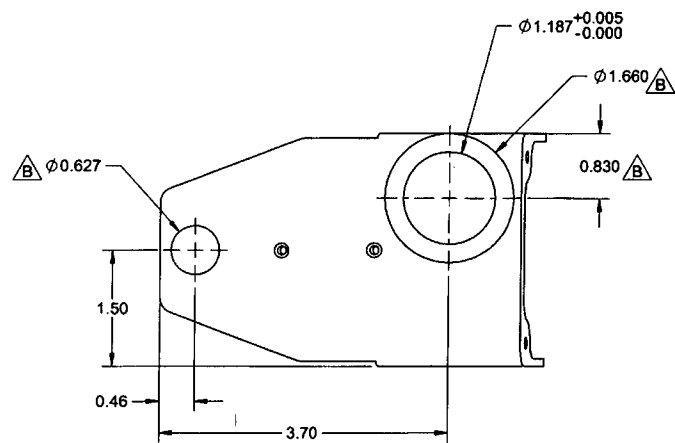
D5155-1 CO-PILOT COLLECTIVE HEAD (205)

DETAIL VIEWS

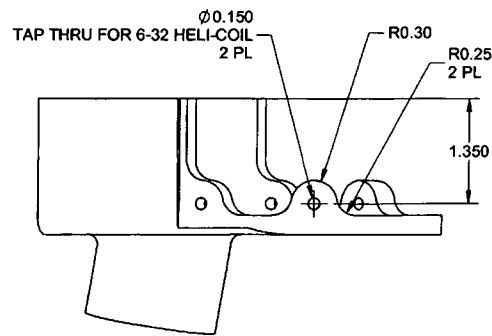
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 6 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

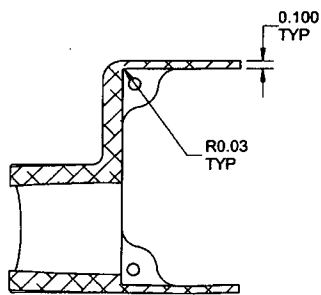
8 7 6 5 4 3 2 1



VIEW G-G
B6-7



VIEW H-H
D7-7



SECTION I-I
D6-7

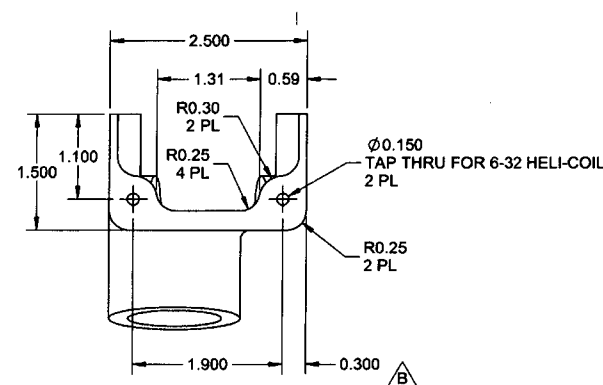
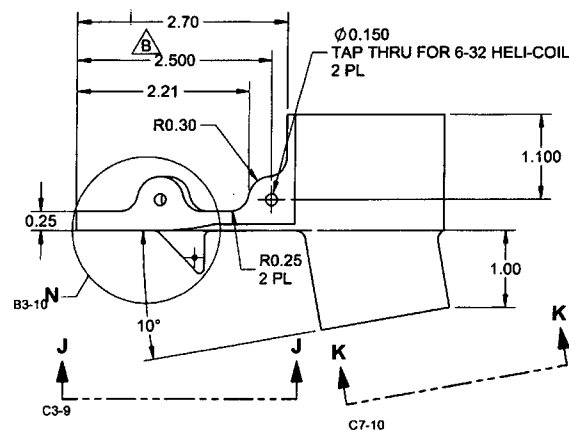
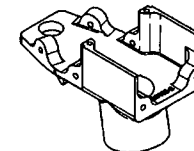
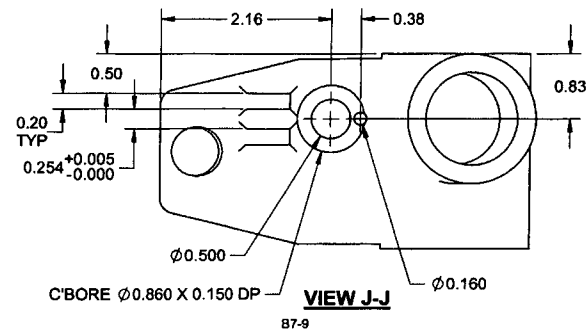
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

RELEASED
A.9. 2015 JUL 02

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 8 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
	DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



RELEASED
A.P. 2015 JUL 02

1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF ASTM SPEC M6061T6B

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

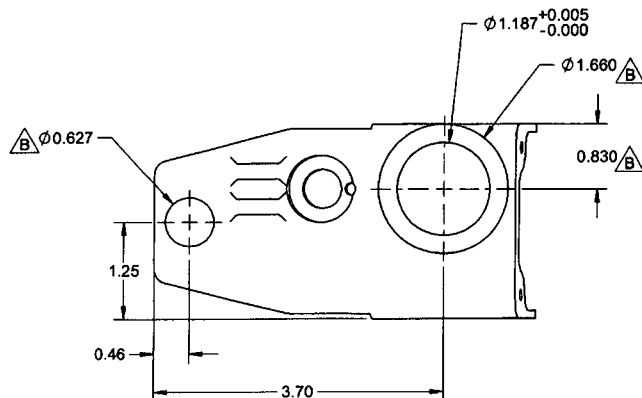
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010

7) WEIGHT: 0,45 lbs

8) UNDIMENSIONED FEATURES DEFINED BY D5155-5.SLDPRT

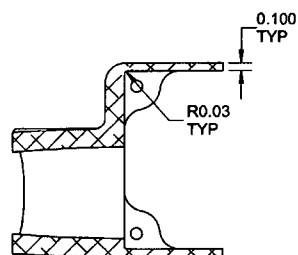
D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. B
	DRAWN	VS		SHEET 9 OF 11
	CHECKED	RF		SCALE
	MFG. APPR.	JFS		NTS
	APPROVED	HS		
	DE APPR.	DS		
	DATE	15.05.21		



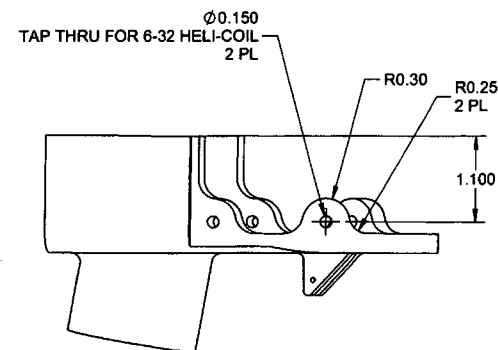
VIEW K-K

B6-9



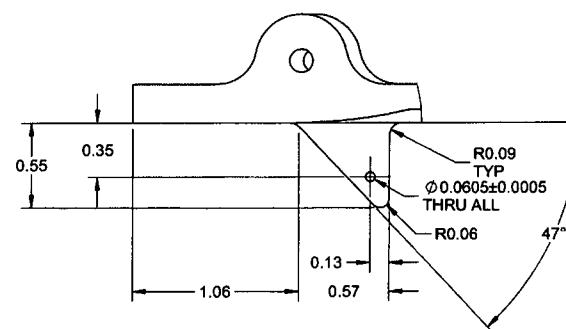
SECTION M-M

D6-9



VIEW L-L

D7-9



DETAIL N

B7-9

RELEASED

A.P. 2015 JUL 02

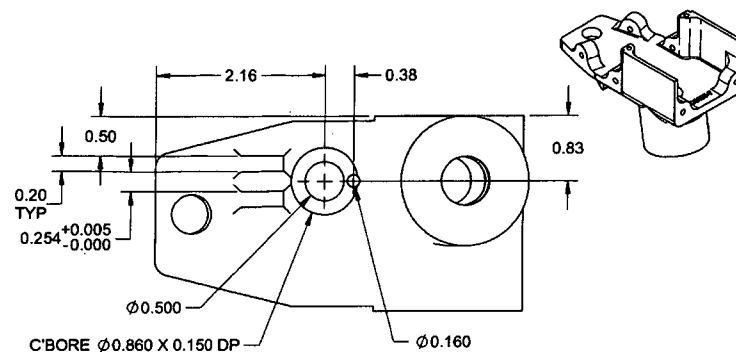
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

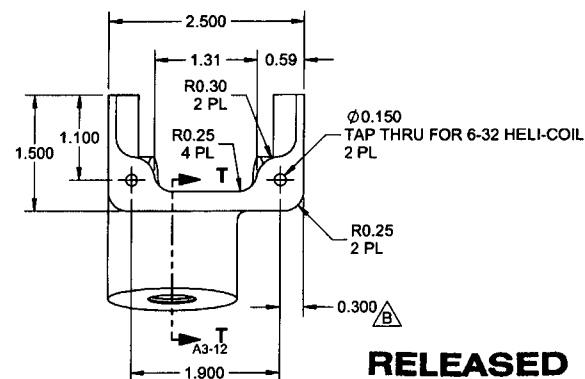
D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
DETAIL VIEWS

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 10 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



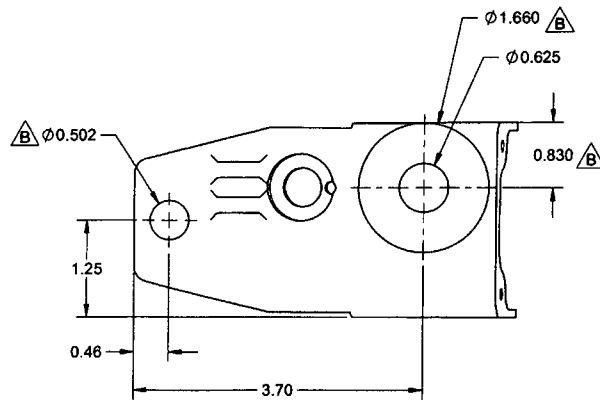
B7-11



A.P. 2015 JUL 02

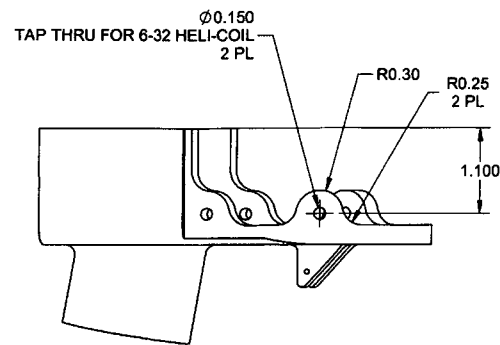
D5155-7 CO-PILOT COLLECTIVE HEAD (205)

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	JFS	D5155	SHEET 11 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NT
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. THIS DOCUMENT IS FOR ANY PURPOSE OR ON ANY COPIERED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



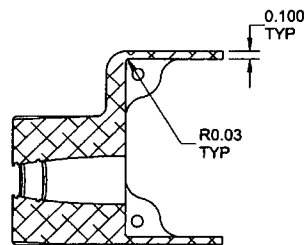
VIEW P-P

B5-11



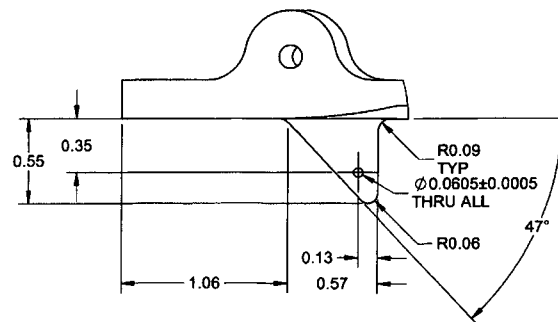
VIEW Q-Q

D7-11



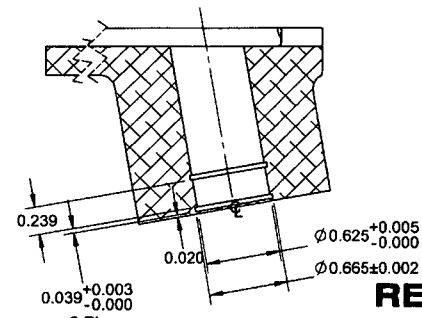
SECTION R-R

C6-11



DETAILS

B6-11



SECTION T-T

B2-11

RELEASED

A.R. 2015 JUL 02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

D5155-7 CO-PILOT COLLECTIVE HEAD (205)

DETAIL VIEWS

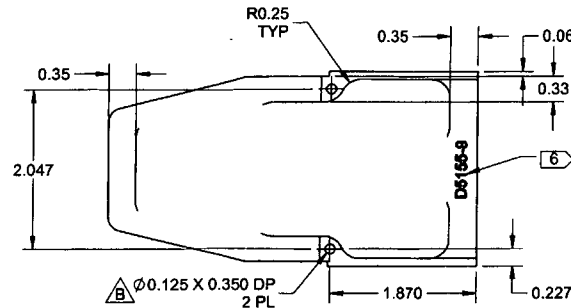
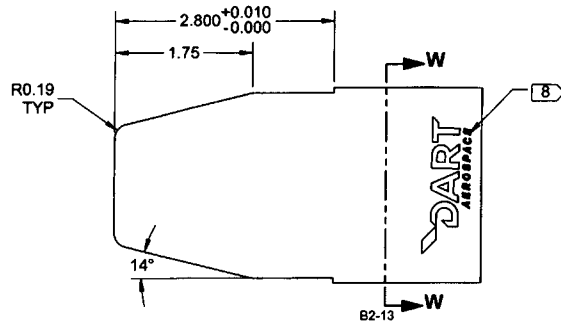
APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

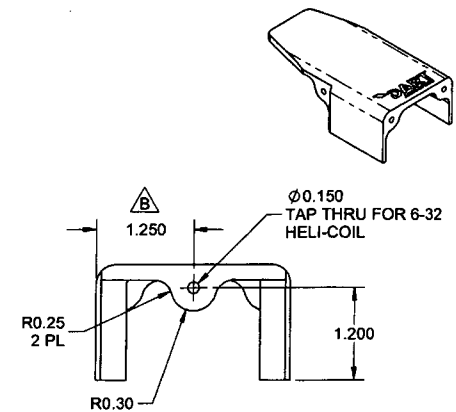
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5155** REV. B
SHEET 12 OF 14
TITLE **CO-PILOT COLLECTIVE HEAD** SCALE NTS

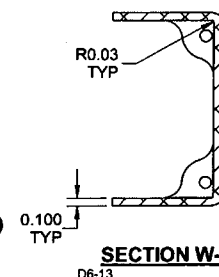
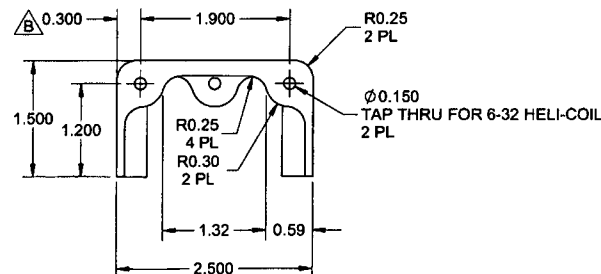
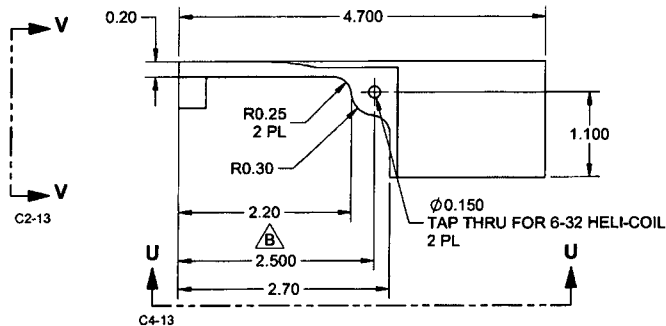
COPYRIGHT © 2013 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



VIEW U-U
B7-13



VIEW N-V
B8-13



SECTION W-W
D6-13

NOTES:

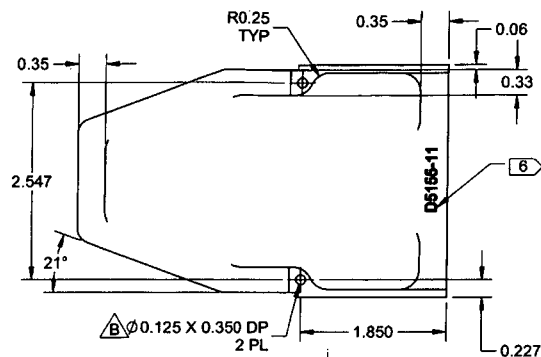
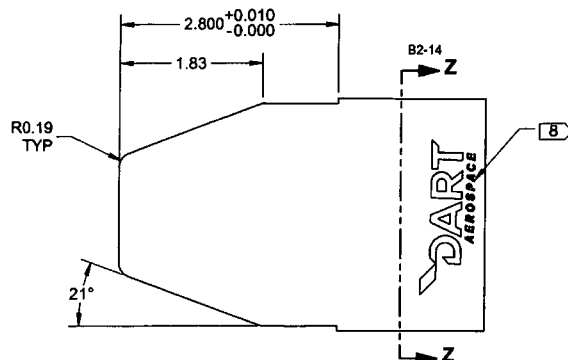
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.31 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9.SLDPRT

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

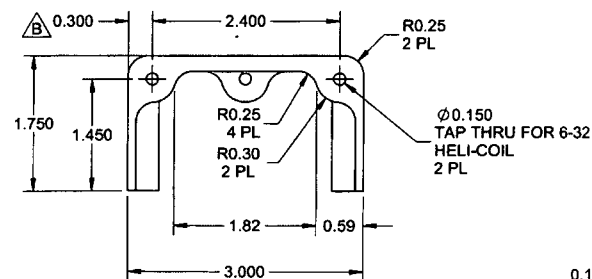
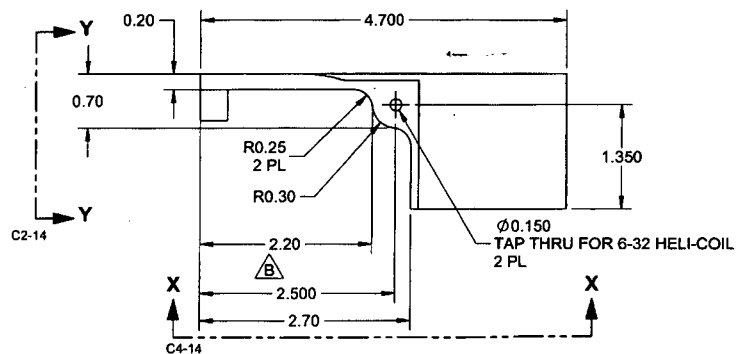
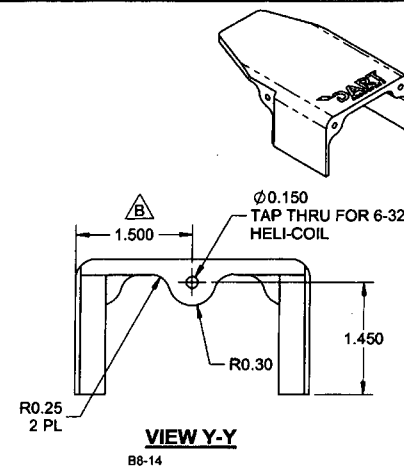
RELEASED
4.9.2015 JUL 02

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 13 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



VIEW X-X
B6-14



SECTION Z-Z
D8-14

RELEASED
A.R. 2015 JUL 02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.36 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPRT

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D5155 SHEET 14 OF 14
TITLE SCALE
CO-PILOT COLLECTIVE HEAD NTS

COPYRIGHT © 2013 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32971**

Purchase Order Date 7/8/2016

PO Print Date 7/13/2016

Page Number 1 of 5

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	<u>Line Comments</u>		<u>Promise Date</u>				
	<u>Delivery Comments</u>						
1	147832	D5155-11 CO-PILOT REV. B	7/18/2016	✓	4.00	\$13.89	\$55.56
			Yes				
			7/18/2016				
		BLACK ANODIZE AS PER MIL-A-8625F TYPE MIL-A-8625F TYPE I/IB/IC/II/IIB CLASS 2					
						Line Total:	\$55.56
2	146050	D5155-043 CO-PILOT REV. B	7/18/2016		5.00	\$13.89	\$69.45
			Yes				
			7/18/2016				
		BLACK ANODIZE AS PER MIL-A-8625F TYPE MIL-A-8625F TYPE I/IB/IC/II/IIB CLASS 2					
						Line Total:	\$69.45
3	146088	D4726-1 HANDLE REV. A	7/18/2016		10.00	\$2.70	\$27.00
			Yes				
			7/18/2016				
		BLACK ANODIZE AS PER MIL-A-8625F TYPE MIL-A-8625F TYPE III, CLASS 2					

Note:

7/13/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911973

Date: 18-Jul-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		BEST WAY	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
4 ea	Part: D5155-11 Co-Pilot Job: 19783	Rev: B PO: PO32971	Line: 1
12 ea	Part: 646.3711 CLIP Job: 19792	Rev: A PO: PO32971	Line: 10
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 19794	Rev: PO: PO32971	Line: 12
17 ea	Part: 646.3715 DOUBLER Job: 19793	Rev: A PO: PO32971	Line: 13
5 ea	Part: D5155-043 CO-PILOT Job: 19784	Rev: B PO: PO32971	Line: 2
10 ea	Part: D4726-1 HANDLE Job: 19785	Rev: A PO: PO32971	Line: 3
10 ea	Part: D4703-043 LOCK PIN Job: 19786	Rev: A PO: PO32971	Line: 4
6 ea	Part: 647.3916 DEFLECTOR Job: 19787	Rev: C PO: PO32971	Line: 5



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911973

Date: 18-Jul-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		BEST WAY	
Quantity	Description		
4 ea	Part: D4974-1 UPPER RAIL Job: 19788	Rev: D PO: PO32971	Line: 6
10 ea	Part: 647.7813 CENTER PLATE Job: 19789	Rev: A PO: PO32971	Line: 7
16 ea	Part: 646.3717 DOUBLER Job: 19790	Rev: A PO: PO32971	Line: 8
2 ea	Part: D4973-1 UPPER CUTTER Job: 19791	Rev: C PO: PO32971	Line: 9
DATE: <u>18/7/16</u> CERTIFIED SIGNATURE: <u>[Signature]</u> RECEIVER SIGNATURE: <u>[Signature]</u> Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA.			